

User

Wednisday, 5/16/2007 8:13:15 AM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 32373

Estimate Number

: 11057

P.O. Number This Issue Prsht Rev.

: NIA : 5/16/2007

: 29108

: NC : WA

S.O. No. : NIA

Type

: PURCHASED PARTS

First Issue Previous Run

Written By

Checked & Approved By

Comment

Drawing Name

: 02.250 SUPPORT

Part Number

: D28911

Drawing Number

D2891 REV A1

Project Number Drawing Revision : N/A

Material Due Date NA:

: 6/5/2007

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

10

PURCHASING



Comment: PURCHASING

Issue P/O: __3795

Description: D6104-003

Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104

Material release note required. Blank size makes (2) D2891-1

20

30

D6104003

17-4 SS Roundbar 3.25"OD

1207/05/17



Comment: Qtv.:

1.0000 Each(s)/Unit

Total:

16.0000 Each(s)



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieive & Inspect for Transit Damage

Ensure Material Release Note is attached

40

MORI SEIKI

MORI SEIKI ENC LATHE LARGE





Comment: MORI SEIKI LATHE

Turn blank for Haas as per Folio FA046

5.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET



Wednesday, 5/16/2007 8:13:15 AM Date: **Process Sheet** Kim Johnston User: Drawing Name: 02.250 SUPPORT Customer: CU-DAR001 Dart Helicopters Services Part Number: D28911 Job Number: 32373 Job Number: Description: Machine Or Operation: Seq. #: HAAS CNC VERTICAL MACHINING #1 6.0 HAAS1 Comment: HAAS Machine as per Folio FA046 Tumble & Deburr INSPECT PARTS AS THEY COME OFF MACHINE QC2 7.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK QC8 8.0 02/02/04 Comment: SECOND CHECK SPRAY PAINTING SPRAY PAINTING 90 7/0: 4102 C407/07/05 Comment: SPRAY PAINTING -PRIME - PAINT DELFLEET BLUE -CLEAR DELFLEET INSPECT SPRAY PAINT QC14 Comment: INSPECT SPRAY PAINT PACKAGING RESOURCE #1 11.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: OC21 120

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





DART AEROSPACE LTD	Work Order:	32373
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891 Rev. A1		Page 1 of 1

				Re	Recorded Actual Dimensions		ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
				Lathe	e Section				
А	2.274	2.279		2.275	2.276	3278	2,277		
В	3.702	3.722		2.574	3.712	2,714	2710		
C	2.564	2.584		2.514	X. 764	3574	2.174		
D	0.718	0.738		753	.730	.730	.730		
E	0.090	0.110			.090	.090	.090		
F	2.464	2.484		2.474	2474	2.474	2.474		
G	2.029	2.049		2032	2.036	2.032	2.032		
Н	2.964	2.984		2.974	2.974	2.574	2.974		
i	0.913	0.933		,918	,919	-919	919		
j	0.022	0.042		.032	032	1032	.032		
K	0.090	0.110		.099	.699	.095	.098		
L	0.000	97,715							
-				HAAS	S Section				
AA	0.188	0.193	DT8706	-/89	189	.189	8 189"		
AB	0.240	0.260		250	248	- 248	242"		
AC	0.115	0.150		.124	-125	./25	12511		
AD	0.040	0.060		-653	.048	.052	252		
AE	0.010	0.020		-015	.015	.015	015"		
AF	0.240	0.260		-250	.250	-250	Q 250		
AG	0.290	0.310		,300	.300	-300	305"		
AH	0.230	0.150		-/30	./32	.131	725"		
Al	0.454	0.474		.460	462	-461	725		
AJ	2.779	2.789		2.784	2754	2,784	2 724"		
AK	0.240	0.260		-250	250	-250	B. 250		
AL	1,002	1.042		1.040	1.039	1042	1.042		
AM	0.053	0.073		E20 -	-063	·CX.3	A.063		
AN	0.257	0.262	DT8683	259	-259	-259	18 257		
AO	1.663	1.683		1.665	1.673	1.673	1 6721		
AP	0.053	0.073		- 663	-063	.003	8 063"		
AQ	0.022	0.042		032	-032	-032	B 222"		
AR	0.022	DIVIL					-032		
AS									
AU	Acc	cept/Reje	ct						

710							
-	Accept	/Reject		19			
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Wice	Date: 0	7/06/07/0	geometri		Date:	07/07/0	04
		1 1 /	07/06	117		Revised by	Approved
Rev	Date	Change					Approved
Λ	02 12 12	New Issue				KJ/RF 1	-1-

DART AEROSPACE LTD	Work Order:	32373
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891 Rev. A1		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	(Z)2	62	7 3	34	Ву	Date
				2.278 Cathe	Section				
A	2.274	2.279		2-3-34/	2.278	3.277	0.23		
В	3.702	3.722		3.710	3.710	3.910	3.713		
C	2.564	2.584		2,574	2.574	2.574	2.544		
D	0.718	0.738		,730	.730	732	.731		
E	0.090	0.110		.090	.100	103	,101		
F	2.464	2.484		2.474	2.474	2.474	2.474		
G	2.029	2.049		2.030	2.040	2.040	2.040		
		2.984		2,974	2.974	2.474	2.974		
Н	2.964	0.933		,927	971	,920	. 930		
	0.913			.037	.037	.032	.037		
J	0.022	0.042			- 100	. 099	100		
K	0.090	0.110		-100	- 600		1.00		
L				HAAG	Caption		-		
				HAAS	Section	1	4		
AA	0.188	0.193	DT8706	0 184"	. 189	189	.189		
AB	0.240	0.260		255	252	:253	249		
AC	0.115	0.150		1/25	:/25	1.25	125		
AD	0.040	0.060		054	:052	0.22	7958		
AE	0.010	0.020		0/5"	-615	-015	-015		
AF	0.240	0.260		R 250	-25C	-250	250		
AG	0.290	0.310		30.5	-300	300	-300		
AH	0.115	0.150		1/25"	-129	.130	./30		
Al	0.454	0.474		455	.460	-457	-463		
AJ	2.779	2.789		2784	2781	2784	2.784		
AK	0.240	0.260		250	-250	250	.250		
AL	1.002	1.042		7.042	1.042	1.037	1.042		
	0.053	0.073		.003	.063	063	063		
MA	0.053	0.262	DT8683	0 257	-259	.257	329		
AN	1.663	1.683	D10000	11:672	1.60-71	1671	1673		
AO		0.073		,063	063	-063	CV63		
AP	0.053	0.073		032	032	. 632	032		
AQ	0.022	0.042		2.20					
AR				+					
AS		cept/Reje	-4	-					

	1		
Measured by: \$ 5	-31 , T.F.	Audited by	-mk
Date: 07/08/07/	2106/11	Date:	07/07/04

Day	Date	Change	Revised by	Approved
Rev		2	KJ/RF - 1	_11
A	02.12.12	New Issue	10/10	75

DART AEROSPACE LTD	Work Order:	32373
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891 Rev. A1		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	q	18	/3	12a	Ву	Date
				Lathe	e Section				
Α	2.274	2.279		12.275	2.278	2.278	2.2785		
В	3.702	3.722		3.713	3-7B=7	3-713	3.714		
C	2.564	2.584		2.574	2. 224	0.514	2574		
D	0.718	0.738		728	,723	,729	730		
E	0.090	0.110		101	1101	101	1/01		
F	2.464	2.484		2.474	2474	3.474	2474		
G	2.029	2.049		2.040	2.040	2,040	2.040		
Н	2.964	2.984		2.974	2.974	2.974	2. 974		
1	0.913	0.933		.929	- 929	,929	,929		
<u> </u>	0.022	0.042		1034	1332	1032	037		
K	0.022	0.110		100	100	-100	./01		
L	0.090	0.110							
L				HAA	S Section				
			070700	4/0-3/25/2	-189	189	./89		
AA	0.188	0.193	DT8706	./89	248	1549	1251		
AB	0.240	0.260		250		125	./23		
AC	0.115	0.150		125	-/25	056	.057		- 15
AD	0.040	0.060		.057	.058		.015	1	
AE	0.010	0.020		.015	.015	.015	-520		
AF	0.240	0.260		-250	-250		365		
AG	0.290	0.310		.305	-305	-305	129		
AH	0.115	0.150		-131	./32		-17/		
Al	0.454	0.474		-460	151	2.78H	2.784		
AJ	2.779	2.789		2.784	2.784		.250		
AK	0.240	0.260		.250	-250	-250	1.642		
AL	1.002	1.042		1.042	1041	1.036		-	
AM	0.053	0.073		.063	-063	.063	-259		
AN	0.257	0.262	DT8683	259	. 259/	7259	1.674	-	
AO	1.663	1.683		1.674	1.674	1674			
AP	0.053	0.073		_063_	- 063	.0.3	-063	-	
AQ	0.022	0.042		.032	632	.030	1032	-	
AR						-		-	
AS							-		
	Ac	cept/Reje	ct]		1	1	

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Date: 07/04/01	103/06/09	Date:	07/07	409

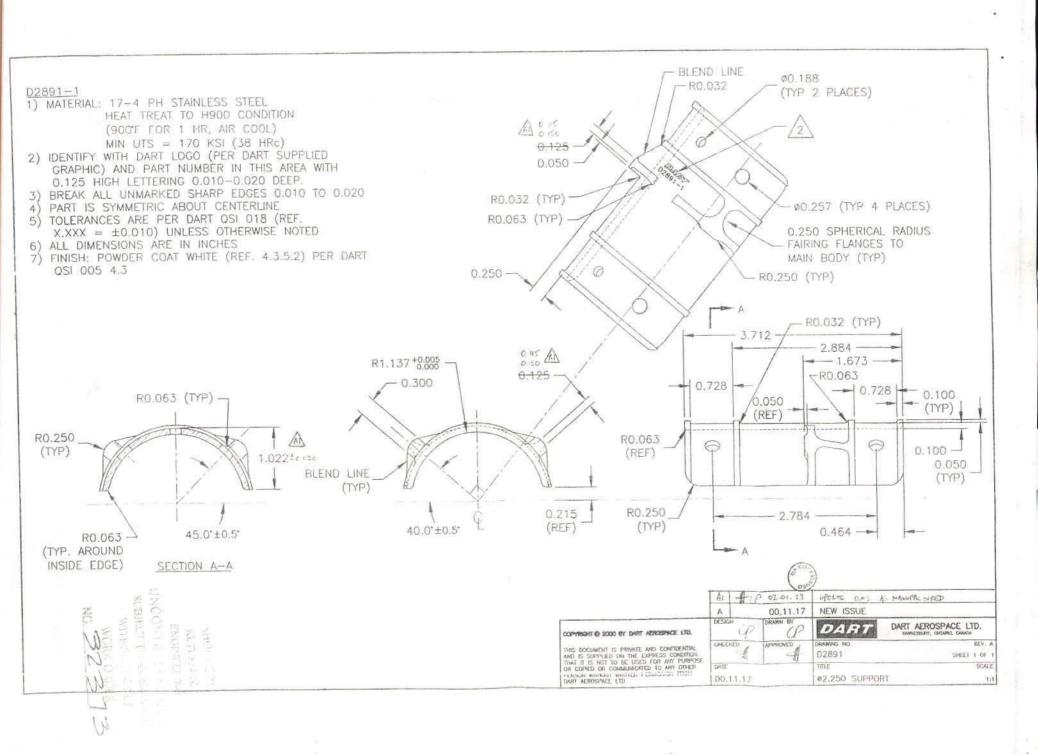
D	Date	Change	Revised by	Approved
Rev			KJ/RF - 1	M.
A	02.12.12	New Issue	KU/KI	77

DART AEROSPACE LTD	Work Order:	32373
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891 Rev. A1		Page 1 of 1

A 2 B 3 C 2 D 0 C E C C C C C C C C C C C C C C C C C	Min 2.274 3.702 2.564 0.718 0.090	Max 2.279 3.722	Go/No Go Gauge	13 Lathe	14	153	164	Ву	Date
B 3 C 2 D 0 C E C C C C C C C C C C C C C C C C C	3.702 2.564 0.718 0.090	3.722		Lathe				2.6	
B 3 C 2 D (C E (C C C C C C C C C C C C C C C C C	3.702 2.564 0.718 0.090	3.722			Section				
B 3 C 2 D (C E (C C C C C C C C C C C C C C C C C	3.702 2.564 0.718 0.090	3.722		T2.277	3.277	2.37/	2271		
C 2 D C C C C C C C C C C C C C C C C C	2.564 0.718 0.090			3.706	3.710	3710	3710		
D (C) E (C) C (C)	0.718	2.584		2574	2.57V	2.574	2.574		
E (G 2 4 1 1 (G 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	0.090	0.738		.730	,730	.730	.730		
F 2 G 2 G 1 G 1 G 1 G 1 G 1 G 1 G 1 G 1 G		0.110		1131	131	.101	.701		
G 2 H 2 H 2 H 2 H 2 H 2 H 2 H 2 H 2 H 2	2.464	2.484		2.474	2474	2.474	2.474		
H 2 1 () J () K () L	2.029	2.049		2 000	7.0010	2.0-10	2.043		
I () () () () () () () () () (2.029	2.984		2.974	2.974	2.974	2,974		
J (K (L)		0.933		225	.429 .	890	.910		
K (0.913	0.042		1032	.032	.032			
AA (0.022	0.042		1,101	-099	-094	032		
AA (0.090	0.110		1,101	- 0				
				LIAAS	Section				
					The second second	Lina	1<0		
AB (0.188	0.193	DT8706	. 189	189	189	189		
	0.240	0.260		.248	-25	.248	725		
	0.115	0.150		./24	.125	-125	./25		
AD (0.040	0.060		.060	-060	-022	.052	-	
	0.010	0.020		.015	-015	-015	-015		
	0.240	0.260		250	-250	-250	250		
	0.290	0.310		-305	-300	.300 -	300		
	0.115	0.150		-/30	./31_	./31	-131		
	0.454	0.474		-454.	.454	-464	464		
	2.779	2.789		12784	2784	2.784	2-784		
	0.240	0.260		250	250	250	-250,		
	1.002	1.042		1.042	1.039	1.041	1042		
	0.053	0.073		063	-063	-de3	-063		
	0.257	0.262	DT8683	-259	259	-254	-259		
	1.663	1.683		1.670	1.672	1.671	164		
	0.053	0.073		.063	-063	-063	.063		
	0.022	0.042		-032	.032	.032	-032		
AR	0.022	0.012							
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Measured by: 3-/	5.1	Audited by	9nl
Date: 07/06/57 /C	7/07/04	Date:	07/07/04

Rev	Date	Change	Revised by	Approved
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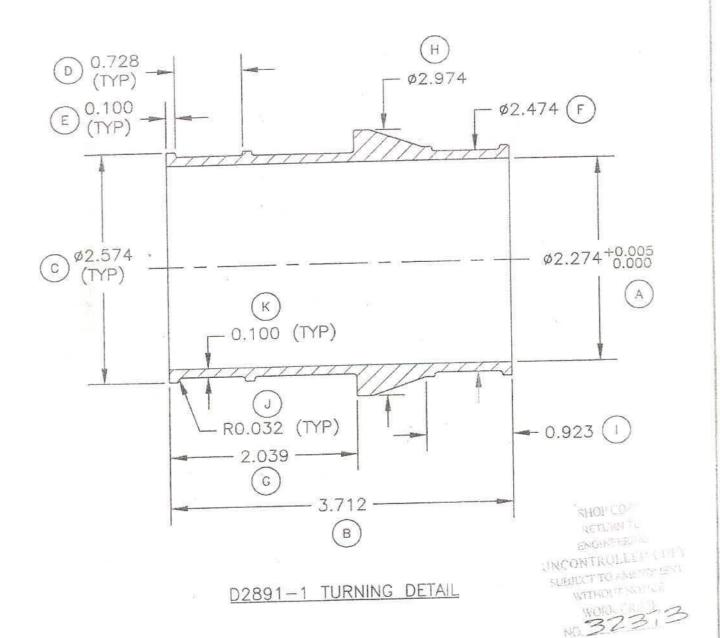




DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. A	
DATE 03.05.20		TURNING DETAIL FOR D2891-1	SCALE 1:1	
Δ	03.05.20	NEW ISSUE		

BELEASED

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AM Castle & Co. (Canada) Inc. DE POUR EXPEDITION SELEMENT. VOIR PRACTURE ERI LA CORRE DU CHAUFFEUR FOUR RECEITION DI PERIAL ET, SI VERRIFIC CERTIFICAT D'ANALYSE POOS COM. WILLIAMS PO	crés ce document rencontrera et est cor	forme aux E PRIOR DIST/ORD: Ø	1 931733	11 0 1 1 1	HOR	
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86-86-187 09:37 SF \$15,50-A CERTIFICATE OF TEST P.O. BOX 977 SYPACUSE **NEW YORK 13201** curi oacea : F1-17-12 A M CASTLE, THE A H CASTLE . INC 3400 H WOLF RE IL SOLNI 3400 W WOLF RD FRANKLEH FART. 60131 FRANKLIN FARK. IL SHIPPED CUSTOMER REQ. N FROM CLISTOMER ORDER IS & DATE DISTRICT B PARSUNS 01-23367 87.75 DESCRIPTION OF MATERIAL 3.250 RD ERU 17-4PH RT A BAC 42470 ASIN-A504-04 7630 ASHE-64004-04EU 1630 AMC 3174-10 REV 7 UNS-817400 A181 630 AMS-56430 (EX SURFACE) CHEMICAL ANALYSIS MEAT NO. CU HU MI SI EX. & 2128 LL 1:04 15.20 A10364 .45 .030 .018 V334 .66 CASTLE METALS FP DATERECO DISIDA APPROVED BY MECHANICAL PROPERTIES DUANTITY HEAT NO. REDJAMENT TEMBLE P51 TLD:2%P51 LELUMBAN 1187 # ALS564 CAPABILITY PHYSICALS AFTER 400 DEG. F. - 1 HE. AIRCOGL: 160.640 203,660 MACRO TEST DK FERRITE 3 % MAGNAFLUX P/4 # 0/0 HATERIAL SOLUTION THEATER AT 1900 DEG. F. HELD OF MINUTES AT TENDERS OF AIRCOOLED. CRUCIBLE HATERIALS CORP. VEHOUR \$18610. HATERIAL LABOT CASY. MARTA - YES THANK YOU FOR SELECTING A QUALITY ESCLA MATERIAL FREE FROM MERCURY CONTAMINATION AT TIME OF SHIPMENT MANUFACTURED BY THE ENFLOYEES OF CRUCTBLE SPECIALLY DECELS THE ABOVE MATERIAL WAS MANUFACTURED AND TELED IN ACCURATION ABOVE SPECIFICATIONS AND IS IN CONFORMANCE OF THE SECOND AND ADDRESS OF THE SECOND NO WELD REPAIR PERFORMED MATERIAL MELTED IN U.S.A.

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SWORN TO AND SUBSCRIBED BEFORE ME THIS

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ERTIFICATE OF TEST SYRACUSE NEW YORK 13201

A M CASTLE, INC A M CASTLE , INC 3400 N WOLF RD 3400 N WOLF RD O FRANKLIN PARK, IL 60131 11 FRANKLIN PARK, IL 00101

514-695-3181

SIMPPED CUSTOMER REQ. II CUSTOMER ORDER # & DATE DISTRICT FROM SYSALTIES D RARSONS 02427267

DESCRIPTION OF MATERIAL

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REAT NO.

MECHANICAL PROPERTIES

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